Work Order ID 102522 Tuesday, May 28, 2013 2:21:45 PM D3007-1 Item ID: *N900040100* Accept Setup Start **Revision ID:** Strut Item Name: **Start Date:** 5/28/2013 Start Qty: 2.00 **Cust Item ID:** Required Date: 5/31/2013 Req'd Qty: 2.00 **Customer:** Reference: Run **Process Plan:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool# Set Up/ Tool ID Plan Accept Reject Reject Insp. Work Center ID Qty Qty **Description Run Hours** Code Number Stamp Draw Nbr **Revision Nbr** D3007 Rev A1 100 0.00 Small Fab *100* Small Fab 0.00 Memo Small Fab 1- Drill one end as per Dwg D3007 2- Touch up hole with paint as necessary 110 QC5- Inspect part completeness to step on W/O *110* QC Memo Quality Control Identify as per dwg & Stock Location: 120 *120* Packaging Memo Packaging

DQA:		- Date:			- WORK ORDER NON CONSORMANCE (URD 177									
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only									
Work Orde					DISPOSITION			AGAINST						
Part N					Rework Scrap			Skid-tube Crosstube Machining Small Fab	-	Pro	Water Jet d. Eng. Coor.	Engineering Quality		
NCR N				-	Use-as-is Suspected Unapproved		Thermoforming Finishi Large Fab Composi			Rec/Sto	Other			
Root				Desci	ription of work order update	[Initial	Action		Sign &				
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Γ	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
Γ	Centre Not Concentric				BOM/Route	Grain				Over/Under	tolerance	Set-up		
ſ	Cracks				Broken/Damage/Defect		Hardwa	ire	Г	Part Incorred	et 📙	Temperature/Cure		
Γ	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
	Cuffs				Contamination		1	tions Incomplete/Unclear		Part Moved	Ť	Wrong Stock Pulled		
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Page 2

Tuesday, May 28, 2013 2:21:46 PM Item ID: D3007-1 Accept Setup Start **Revision ID:** Stop Item Name: Strut 5/28/2013 Start Qty: 2.00 **Start Date:** Cust Item ID: Required Date: 5/31/2013 Req'd Qty: 2.00 **Customer:** Reference: Run **Approvals: Process Plan:** Tooling: Date: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool # Plan Reject Insp. Set Up/ Tool ID Accept Reject Work Center ID Description Qty Qty Number Stamp **Run Hours** Code 130 QC21- Final Inspection - Work Order Release 0.00 mc5 13-05-29 MP 13-5-29 *130* QC 0.00 Memo Quality Control

DQA:			Date:													
						WORK ORDER NON-CONFORMANCE / UPDATE										
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						Rework			Skid-tube Crosst	ube	7	Water Jet	Fng	gineering		
Part I	No.					Scrap			Machining Small	—	Prod. Eng. Coor.			Quality		
	_					Use-as-is		i	moforming Finish		-	re/Packaging	┪	Other		
NCR I	۷o					Suspected Unapproved			Large Fab Compo	site		Supplier				
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	Centre Not Concentric					BOM/Route		Grain			Over/Under	tolerance	Set-u	р		
	Cracks					Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temp	erature/Cure		
	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld			
	Cuffs					Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wron	g Stock Pulled		
	· Crushing					Countersink		_	ned/off center		Positioned W	_	_			
Heat Treat						Cut Too Short		Mislabe		L	Power Loss/Surge					
	_	•	Strip in	Tube		Drawing		Misread								
	-	1arks/Ch				Drill Holes		Off-set								
	_	urning Se				Finish		1	Calibration							
	Wave/Twist in Tube					Fit/Function	Out of Sequence									

Page 1

Tuesday, May 28, 2013 2:21:43 PM

Work Order ID:

102522

Parent Item:

D3007-1

Parent Item Name:

Strut

Start Date: 5/28/2013

Required Date: 5/31/2013

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP A01.03.23New IssueEC

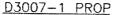
Commence.														
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D2704		Manufactured	No			100	Each	3.0000	1	2)
Cross Brace												\rightarrow	13(ax1	

DQA: Date:						- ΔΔDT										
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only										
Work Orde	er:					DISPOSITION				AGAINSI D	EPARTMENT	/PROCESS				
	_				_	Rework			Skid-tube	Crosstube		Water Jet .	Engineering			
Part i	No					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR I	No					Suspected Unapproved			Large Fab	Composite		Supplier				
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	-	Bending				Bend	Folio/Program				Outside Dim	ensions	Pressure/Forced			
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	Crimp/Kink/Ripple/Wave					Burrs		1	on Incomplete/Un	· -	Part Lost/Mi	ssing	Weld			
	Cuffs					Contamination		1	ions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled			
	Crushing					Countersink	<u> </u>	1	ned/off center	<u> </u>	Positioned V		٦			
	Heat Treat					Cut Too Short	L	Mislabe			Power Loss/	Surge	Other			
	_	nspection		Tube		Drawing	<u> </u>	Misread	I							
	\vdash	Marks/Ch				Drill Holes		Off-set								
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	Wave/Twist in Tube					Fit/Function		Out of S								

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



-PROP ENDS 0° OFFSET



MATERIAL: AISI 304/316/318 SS TUBE, Ø0.50 X 0.035 WALL ENSURE SEAMLESS TUBE IS USED CAN MAKE FROM D2704



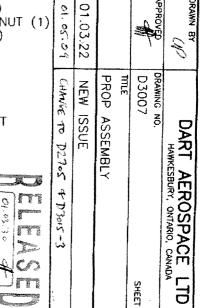
D2012-107 CLEVIS

D2012-107 CLEVIS

AN4-10A BOLT (1)
D2022-101 SPACER (2)
AN960JD416 WASHER (1)
MS21042L4 NUT (1)
(ATTACH LOOSELY, MUST BE REMOVED DURING INSTALLATION)

D3007-041 PROP ASSEMBLY

GENERAL NOTES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



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01.03.22

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	-					Rework			Skid-tube Crosstube]	Water Jet	Engineering			
Part f	No.					Scrap			Machining Small Fab	,	Pro	d. Eng. Coor.	Quality			
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		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct <u> </u>	Temperature/Cure			
	Crimp/Kink/Ripple/Wave				<u> </u>	Burrs		Inspecti	on Incomplete/Unqualified		Part Lost/Mi	ssing	Weld			
	Cuffs					Contamination		}	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
	· Crushing				L.	Countersink		•	ned/off center	L	Positioned V	Vrong _				
	Heat Treat				· L	Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other			
	-	Inspection		Tube		Drawing	Ц	Misread	1							
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	$\boldsymbol{\vdash}$	Turning S				Finish	\bigsqcup	4	Calibration							
		Wave/Tw	ist in Tub	e		Fit/Function		Out of Sequence								